



**HARRY HERSBACH
TOOLS BV**

specialist in machining tools

2020
23



COMBIDEX®

solid solutions to improve your business

PARTING OFF

THREADING

MILLING

THREAD MILLING

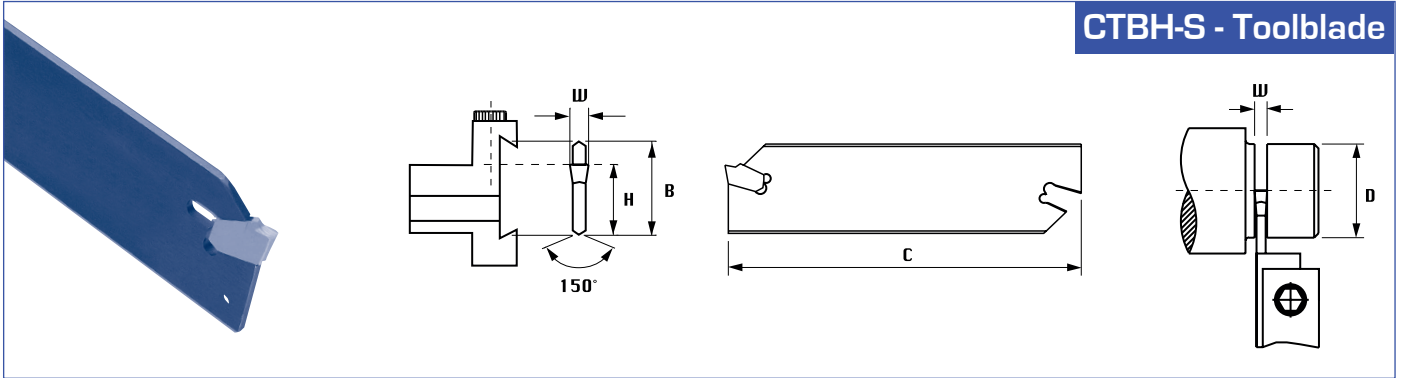
TURNING

DRILLING

GROOVING & PARTING

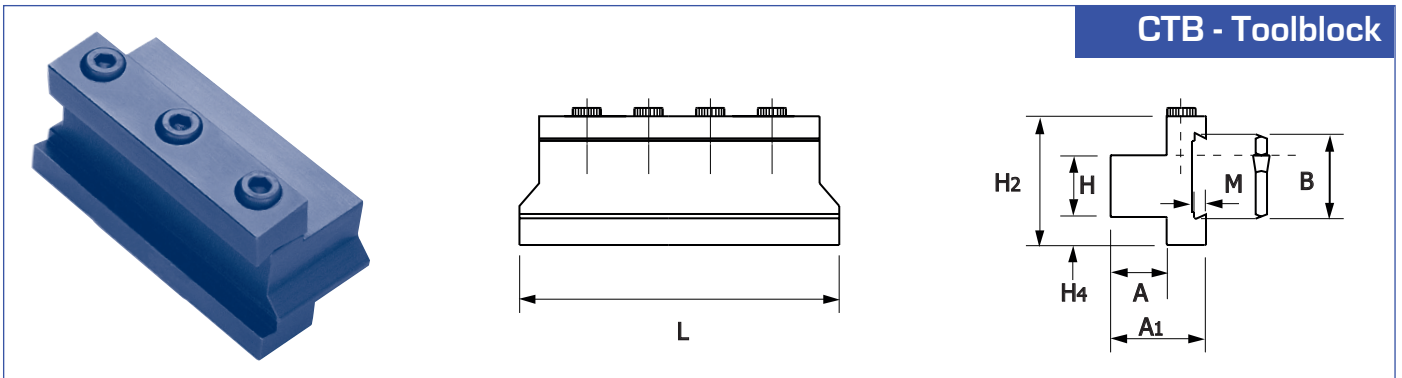
	Specifications	Page
CTBH-S	Toolblade	3
CTB	Toolblock.....	3
CPH-S	Parting Toolholder	4
CTL/N/R	Insert.....	4
CUTTING CONDITIONS	5

CTBH-S - Toolblade



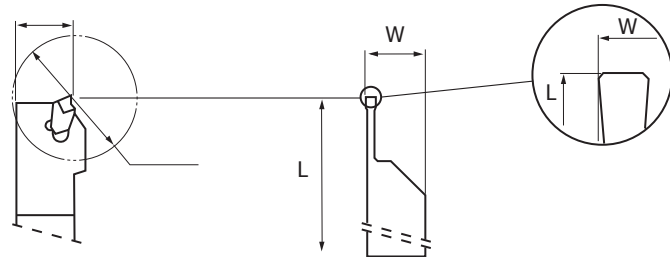
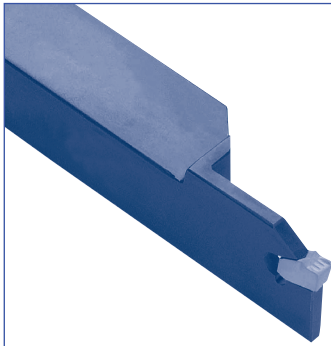
Ordering Code	W	B	C	H	D
CTBH 19 - 2 S	2.2	19	86	15.4	40
CTBH 26 - 2 S	2.2	26	110	21.4	50
CTBH 26 - 3 S	3	↓	↓	↓	75
CTBH 26 - 4 S	4	↓	↓	↓	80
CTBH 26 - 5 S	5	↓	↓	↓	80
CTBH 26 - 6 S	6.4	↓	↓	↓	80
CTBH 32 - 2 S	2.2	32	150	25.0	40
CTBH 32 - 3 S	3	↓	↓	↓	100
CTBH 32 - 4 S	4	↓	↓	↓	100
CTBH 32 - 5 S	5	↓	↓	↓	120
CTBH 32 - 6 S	6.4	↓	↓	↓	120

CTB - Toolblock



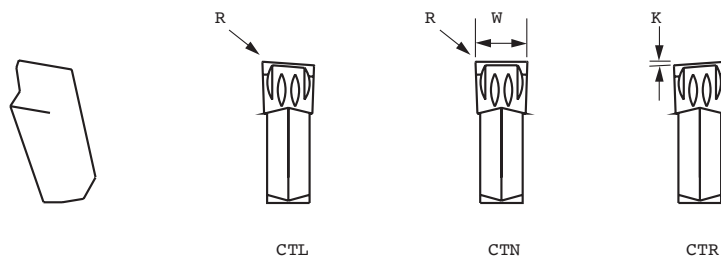
Ordering Code	H	B	A	A1	H2	H4	M	L
CTB-P 16 - 2	16	19	16	26	30	4	2.0	76
CTB-P 16 - 5	16	26	16	30	38	12	4.0	76
CTB 20 - 5	20	26	19	33	38	8	4.0	87
CTB 20 - 6	20	32	19	35	48	13	5.5	100
CTB 25 - 6	25	32	20	36	48	8	5.5	110
CTB 32 - 6	32	32	28	44	48	3	5.5	120
CTB - P								Partial Block

CPH-S Parting



Ordering Code	H(h)	W	L	Dmax
CPH 320 - S (R/L)	20	20	120	40
CPH 420 - S (R/L)	20	20	120	50
CPH 325 - S (R/L)	25	25	150	50
CPH 425 - S (R/L)	25	25	150	60

CTL/N/R - Insert



GRADES: P40 - PC 35 (COATED) - K10

Ordering Code	W	R	K
CTN - 2V			
CTR - 2V - 8D	2.2	0.15	8°
CTL - 2V - 8D			8°
CTN - 3V			
CTR - 3V - 8D	3.1	0.18	8°
CTL - 3V - 8D			8°
CTN - 4V			
CTR - 4V - 8D	4.1	0.23	8°
CTL - 4V - 8D			8°
CTN - 5V			
CTR - 5V - 8D	5.1	0.28	8°
CTL - 5V - 8D			8°
CTN - 6V			
CTR - 6V - 8D	6.4	0.35	8°
CTL - 6V - 8D			8°

Cutting Conditions

MATERIAL		BRINELL H.B.	CUTTING SPEED		FEED MM/REV.		
			P40	PC35	CTN-2	CTN-3/4	CTN-5/6
Carbon steel	0,20%C	150	80-125	120-180	0.05-0.20	0.10-0.35	0.15-0.45
	0,45%C	190	65-120	100-165	0.05-0.20	0.10-0.30	0.15-0.40
	0,80%C	250	65-120	75-145	0.05-0.15	0.10-0.25	0.15-0.35
Alloy Steel		200	65-120	70-120	0.05-0.15	0.10-0.35	0.15-0.40
		200-250	45-80	60-100	0.05-0.15	0.10-0.30	0.15-0.35
		275-325	40-75	45-85	0.05-0.15	0.10-0.25	0.10-0.30
		325-375	35-50	50-70	0.05-0.10	0.10-0.20	0.10-0.25
		375-425		40-50	0.05-0.08	0.10-0.15	0.10-0.20
		Ferrit.	135-175	60-90	80-110	0.05-0.15	0.10-0.25
Stainless		175-225	75-120	110-150	0.05-0.15	0.10-0.25	0.12-0.35
	Martensit.	275-325	50-90	75-115	0.05-0.10	0.10-0.20	0.10-0.30
		325-375		40-55	0.05-0.08	0.10-0.15	0.10-0.20
Cast Steel	ustenit.	125-175	60-105	90-160	0.05-0.15	0.10-0.20	0.10-0.25
		150	60-120	90-175	0.05-0.20	0.10-0.30	0.15-0.40
		150-200	45-90	65-135	0.05-0.15	0.10-0.25	0.15-0.35
		200-250	40-70	60-110	0.05-0.15	0.10-0.20	0.15-0.30
		250-300	40-50	50-80	0.05-0.08	0.10-0.15	0.15-0.20

MATERIAL	H.B.	K10		CTN-2	CTN-3/4	CTN-5/6
Cast Iron	180	70-100		0.05-0.20	0.10-0.30	0.15-0.45
	250	50-70		0.05-0.15	0.10-0.25	0.15-0.30
Bronze	80-100	100-220	0.05-0.10	0.08-0.20	0.15-0.45	
Magnesium	40-90	350-500		0.05-0.10	0.08-0.20	0.15-0.45
Aluminium	50-150	250-450		0.05-0.08	0.05-0.20	0.10-0.35

